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A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01

128 CLEANER

ACCU-LABS 128 CLEANER is a twofold cleaner. It can be used to soak and electroclean a wide variety of metals, thereby eliminating the need to use and stock several different cleaning compounds. 128 CLEANER may be used to condition steel, copper, brass, zinc base die castings, and tin-lead die castings for uniform and blister free plating results.

ACCU-LABS 128 CLEANER is uniquely formulated to meet the highest quality desirable. Its superior wetting system makes it an excellent soil remover and gives work excellent rinse ability. When used as a soak cleaner, 128 CLEANER displaces grease, oil and shop soil to the surface where they can readily be skimmed off, allowing longer life from the cleaner. When used as an electro cleaner, it removes grease, oil, smut, soil, rust and scale to ensure excellent adhesion of plating on the base metal. 128 CLEANER is biodegradable and can be used without problem in areas where biodegradable materials are required.

EQUIPMENT

ACCU-LABS 128 CLEANER solution may be contained in a plain steel tank and heated with steel steam coils.

MAKE-UP

- **Fill tank $\frac{3}{4}$ full with tap water.**
- **Slowly add required amount of 128 CLEANER while agitating bath.**
- **Fill to final volume.**
- **Heat to desired temperature.**

NOTE: Do not make any rapid additions of material to the water. It may cause an eruption due to the heat generated.

OPERATING GUIDELINES:

Steel, copper and brass parts may be cleaned using either direct or reverse current. For zinc base die castings and tin-lead die casings, parts should be cleaned with reverse current.

SOAK CLEANING:

	Zinc Base Die Castings Tin-Lead Die Castings	Copper & Copper Base Alloys	Steel
Concentration	4 - 6 oz/gal	6 - 8 oz/gal	8 - 12 oz/gal
Temperature	120 - 160°F	160°F	160 - 200°F
Time	1 - 2 minutes	1 - 2 minutes	1 - 2 minutes

ELECTROCLEANING:

	Zinc Base Die Castings Tin-Lead Die Castings	Copper & Copper Base Alloys	Steel
Concentration	4 - 8 oz/gal	6 - 10 oz/gal	8 - 14 oz/gal
Temperature	120 - 160°F	160°F	160 - 200°F
Time	½ - 1 minute	½ - 2 minutes	½ - 2 minutes
Current Density	20 - 60 ASF	20 60 ASF	40 - 100 ASF

SOLUTION CONTROL:

- Pipette 10 ml bath sample into a 250 ml e-flask
- Add 3-5 drops of Bromophenol blue indicator
- Titrate with 1.0N HCl to a blue endpoint
- Mls of 1.0N HCl titrated x 0.68 = oz/gal of 128 Cleaner

CAUTION: 128 CLEANER is alkaline in nature. Contact of the solution or salts with skin or dyes should be avoided. In case of contact, flush with copious amounts of cold water. For eyes, flush with cold water 10-15 minutes and obtain medical assistance.

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